

Date: Tuesday, 13/05/2008 2:23:12 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 39252
 Estimate Number : 13309
 P.O. Number :
 This Issue : 13/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D SM/MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-13 new issue DD verified by:

Part Number : D37911
 Drawing Number : PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 20/05/2008 Qty: 2 Um: Each



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.3063 sf(s)/Unit Total : 0.6126 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: 107676 B 8-5-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3791

Dwg Rev: PRE-L B 8-5-14

Prog Rev: PRE-L

2-Deburr if necessary B 8-5-14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

080514

3

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

080514

3

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Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



PA 06.05.14



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld hardcoat as per dwg D3791 QSI004

(IX)

Hardcoat 2059b Batch: H 107962.

08-05-14

SP

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/05/14 (EU)

9.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

PA 06-05-14

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A

PA 06-05-16

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ens's Lab
NOT FOR STOCK

POSITIVE RECALL

EFFECTIVE 08-05-13

AUTH 11

PA 06-05-21

RELEASED PA

DATE 06-07-15

Date: Tuesday, 13/05/2008 2:23:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39252

Part Number: D37911

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



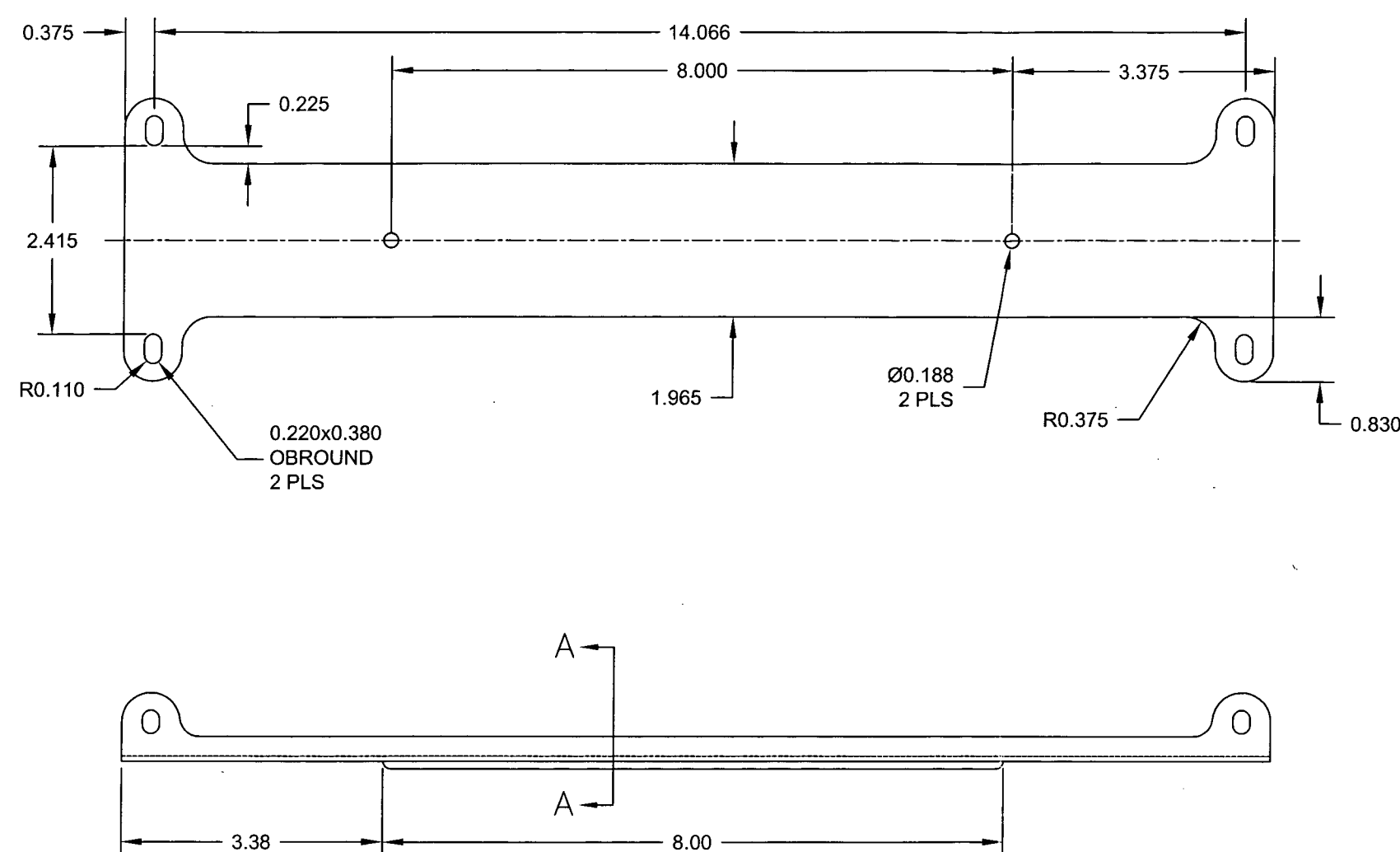
08/05/16 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-16



(D3791-1 WEARPLATE)

PRELIMINARY ISSUE
08.05.13

W/0252

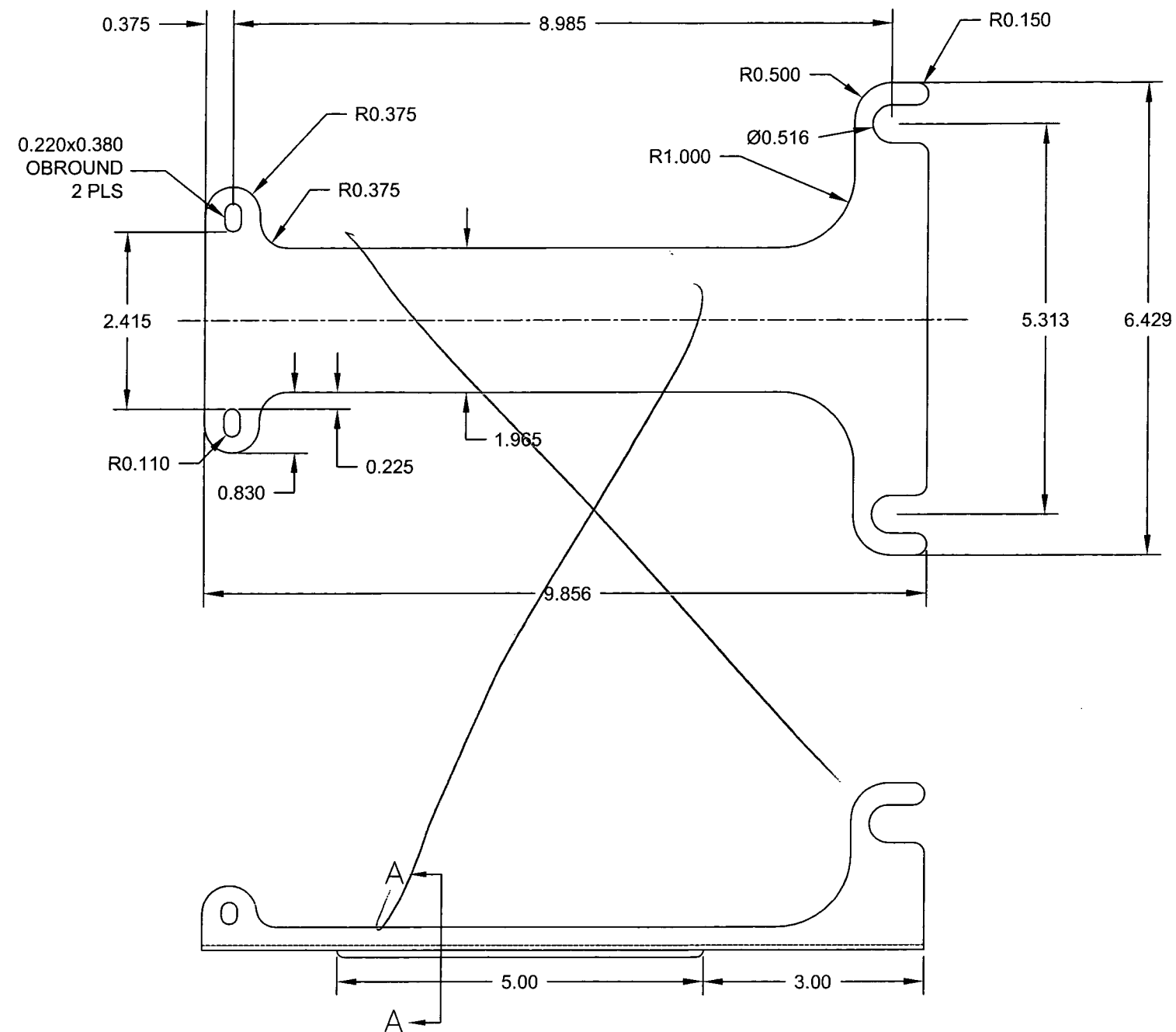
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

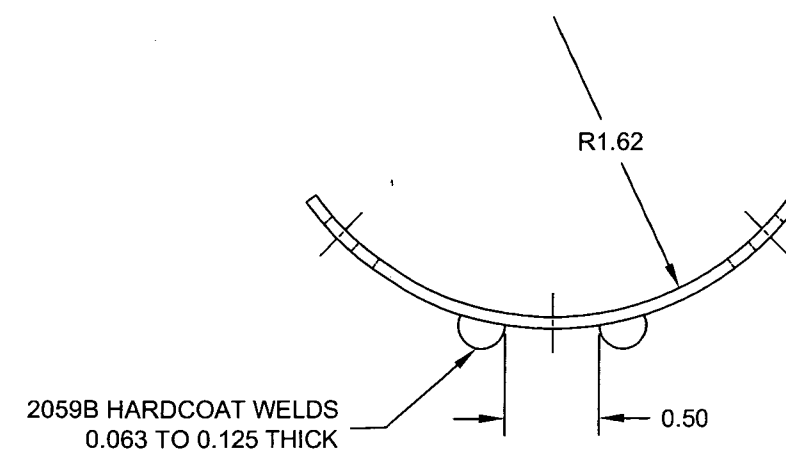
A	NEW ISSUE	PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3791	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	08.05.13	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

D
C
B
A

D
C
B
A



D3791-3 WEARPLATE

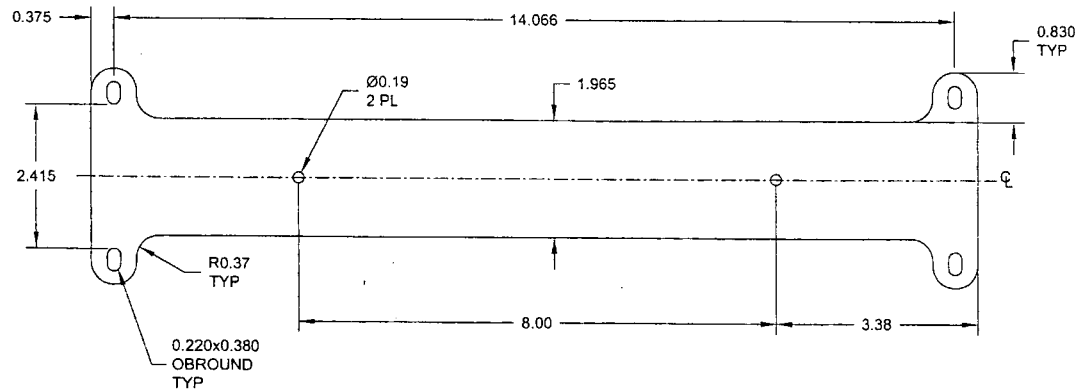


SECTION A-A

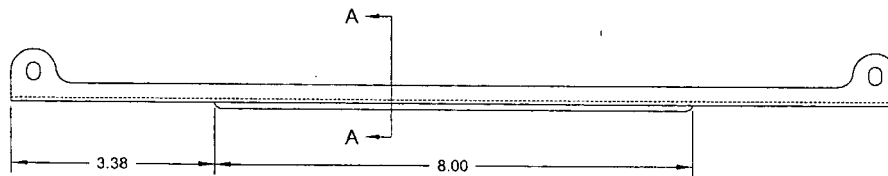
PRELIMINARY ISSUE
01.05.14

DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
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MFG. APPR.		D3791	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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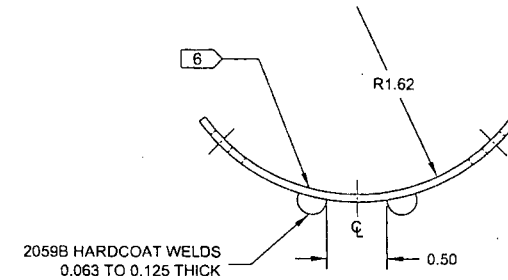
A



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
 (MAKE FROM D3791-1F)



SECTION A-A
 SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A	NEW ISSUE	PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.	DS		
APPROVED			
DE APPR.			
DATE	08.05.13		

DART AEROSPACE USA, INC
 PORT HADLOCK, WA
 DRAWING NO. D3791
 TITLE WEARPLATE
 REV. A
 SHEET 1 OF 1
 SCALE NTS

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 08-05-24-18